

Date: Tuesday, 07/04/2009 11:17:18 AM
 User: Julie Dawson

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D350-636-012
Job Number : 47032	
Estimate Number : 10804	
P.O. Number :	Part Number : D350636012
This Issue : 07/04/2009 S.O. No. :	Drawing Number : R0-017 <i>209-017</i>
Prsht Rev. : NC	Project Number :
First Issue : / /	Drawing Revision :
Previous Run : 00015	Material :
Written By : <i>[Signature]</i>	Due Date : 14/04/2009 Qty: 1 Um: Each
Checked & Approved By : <i>209-04-07</i>	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D350636012	Skidtube RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Skidtube RH
 Original B43781 @ CHG004

2.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

Tube has minor surface scratches, from trail assemblies and will need to be sanded and re-powder coated.

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

✓ Dis-assemble the entire tube, and keep all hardware
 See attached of original reference copy

✓ Identify all hardware as to which work order it belongs to for traceability.

✓ - Wash and remove all LPS product applied to the tube. Interior and exterior, and on the hardware.

✓ Scuff entire tube, with a 320 grit paper for re-powder coating per QSI 005.

Strip. & Polish Re-Align per QSI 005 *M/M 09-05-06* (X)

4.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder coat the entire tube white per QSI005 M *111472*

Start time: *2:20*

Oven Temp: *320°*

Finish time: *2:50*

FL 09/05/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 11:17:18 AM
User: Julie Dawson

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D350-636-012

Job Number: 47032

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description:

Re-powder wearpads Grey as necessary per Q81005. M

Start time:

Oven Temp:

Finish time:

N/A

Wear pads are in good condition
no markings

09-05-12 (X)

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-12 (X)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Re-assemble tubes using existing stock.

If some hardware is replaced record below:

AL54103225 / M110768 Qty 38

D3794-1 / B47212 Qty 1

D3794-3 / B47440 Qty 1

D3536-25 / B47011 Qty 1

AN3C-5A / M111707 Qty 34

A103C-6A / M110392 Qty 4

AN960 C-10W / M111548 Qty 38

MS21083-C8 / M111584 Qty 1

NAS1515H36 / M110806 Qty 4

09-05-12 (X)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign Objects

2-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: M111081

EXP DATE: 10/20

3- assemble o-ring to plug as per dwg D3492 and apply o-ring lube

A/R 55-o-ring lube batch: M1101223

4- Coat all exposed fasteners with "LPS Procyon" batch: M1104251 09-05-12 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: \ Tuesday, 07/04/2009 11:17:18 AM
User: \ Julie Dawson

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D350-636-012

Job Number: 47032

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sort 12 @

***ensure approval e-mail is attached for the removal of LPS 3 on the inside of the tube. *Ala*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

5 9/5/13

New labels and paperwork are required with the new batch #

CHC 0004

JUL 09 04 07 17

10.0

D2741

Blade, 350 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: *B45320*

9/5/13

11.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: *M110742*

*****apply antiseize prior to packaging*****

Batch: ~~106558~~ *M110638*

9/5/13

12.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: *M111424*

9/5/13

13.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: *M1108964*

9/5/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 11:17:18 AM
User: Julie Dawson

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D350-636-012

Job Number: 47032

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M111637

9/5/13

50

15.0

D34931

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: B111902

9/5/13

50

16.0

D35321

Spacer



Comment: Qty.: 2.0000 (s)/Unit Total : 2.0000 (s)

batch: B111909

9/5/13

50

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

*****ensure antiseize is on AN8C21A bolts*****

8/09/05/13

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-012

Rev G

8/09/05/14

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/14

Job Completion



MF 09-08-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 26/11/2008 12:49:42 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 350 SKIDTUBE ASSEMBLY RH
Job Number : 43781	
Estimate Number : 10265	
P.O. Number :	Part Number : D350636012
This Issue : 26/11/2008 S.O. No. :	Drawing Number : D2750 REV F
Prsht Rev. : NC	Project Number : N/A
First Issue : 11	Drawing Revision : F
Previous Run : 43780	Material :
	Due Date : 20/12/2008

Written By :
Checked & Approved By : JD 08.12.09
Comment :
Type : SKIDTUBES

REFERENCE ONLY
Qty: 1 Um: Each

Comment :
Est Rev: I 02-09-25 Rearranged procedure steps KJ
Est Rev: J 06-03-29 As per Rev D EC
Est Rev: K 06-07-13 As per dsi9343 EC
Est Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM
Verified By: EC
Est Rev: M 08-04-22 update steps 4,13 DD verified by: EC
Est Rev: N 08-09-23 revF as per dwg DD verified by: ec

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JD For JD 08.12.09



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-012 CHG 004

2.0	D26003BENT	Extrusion Bent
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2600-3-Bent	Extrusion (Bent)	<u>43495</u>

SL 8-11-29

3.0	D2744	Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch: 39242

SL 8-11-29

4.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 5 (D2750-2 details). Drill using drill Jig DT8150 & DT8863.

SL 8-11-29

Date: Wednesday, 26/11/2008 12:49:42 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 43781

Part Number: D350636012

Job Number:



REFERENCE ONLY

Seq. #:

Machine Or Operation:

Description:

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4-Drill pilot holes for blade fitting bolts using DT8383. Open to 0.500"

5- locate DT8923 off of blade fitting bolt holes and drill pilot holes blade fitting.

6-Open up holes for Detail K to 0.375" (4 holes per side) blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail L to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108. Open to 0.297".

8-Open up holes of Detail J to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod m109813/m109213 *BF 08/12/01*

10-Grind welds flush as per Dwg D2750 *FT 08-12-01*

11- scribe batch #: *FT 08-12-01*

5.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FT 08-12-01

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BF 08-12-02

Date: Wednesday, 26/11/2008 12:49:42 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 43781

Part Number: D350636012

Job Number:



REFERENCE ONLY

Seq. #:

Machine Or Operation:

Description :

26.0

D37943

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

Batch: 1342486

JS

27.0

D353525

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: 1343405

JS

28.0

D353625

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1342980

JS

29.0

D35371

Wearpad



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

WEARPAD

Batch: 1343171

JS

30.0

D36311

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Batch: 1341141

JS

31.0

D3488042

Blade Fitting Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, RH

Batch: 1343122

JS

32.0

NAS1611010

O-RING



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

O-RING

NAS1611-010 batch: M109962

(or MS28775-010) batch: _____

JS

08-12-08

JS

Date: Wednesday, 26/11/2008 12:49:42 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 43781

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

REFERENCE ONLY

33.0

NAS1611013

O-RING



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

O-RING

batch: 11106513

JS

34.0

D3492041

Plug Assembly



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: 1342936

JS

35.0

D3492043

Plug Assembly



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: 1342997

JS

36.0

AN3C5A

Bolt



Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)

Bolt

Batch: 1110002

JS

37.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: 11108880

JS

38.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: 1110105

JS

39.0

AN8C35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: 1110105

JS

08-12-08

20

Date: Wednesday, 26/11/2008 12:49:42 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 43781

Part Number: D350636012

Job Number:



REFERENCE ONLY

Seq. #:	Machine Or Operation:	Description :
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40.0	AN960C10L	washer
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Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

washer

Batch: 11109798

JH

41.0	AN960C816L	WASHER
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WASHER

Batch: 11109632

JH

42.0	MS210436	NUT
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

NUT

Batch: 11109754

JH

43.0	MS21083C8	NUT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

NUT

Batch: 11109740

JH

44.0	NAS1515H3L	WASHER
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Batch: 11106516

JH

45.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"

batch: 11109539

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 11109883

EXP DATE: 09/11

JH 08-12-08 *XL*

Date: Wednesday, 26/11/2008 12:49:42 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 43781

Part Number: D350636012

Job Number:



REFERENCE ONLY

Seq. #:

Machine Or Operation:

Description :

4-assemble o'ring as per dwg D3492 and apply o'ring lube
A/R 55-o'ring lube batch: M1101223

5-Coat all exposed fasteners with "LPS Procyon"
batch: M1104251

21P 08.12.08 (X)

46.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/12/08 (X)

47.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

48.0

D2741

Blade, 350 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Blade
Batch: 6222

30

49.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
Batch: M109632

30

50.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Nut
Batch: M109840

30

51.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
Batch: M109772

8/12/10

30

Date: Wednesday, 26/11/2008 12:49:42 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 43781

Part Number: D350636012

Job Number:



REFERENCE ONLY

Seq. #:

Machine Or Operation:

Description :

52.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: M108964

SP

53.0

D34931

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: 43453

SP

54.0

D35321

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

spacer

Batch: B42350

8/12/10

(2)

SP

55.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8/12/11 (40)

56.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-012

8/14/11 (1)

57.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/15

Job Completion



mf 08-12-12

B47032
B43781

DART

TRANSPORT CANADA APPROVAL # 09-89

TEL : 1-613-632-3336
FAX : 1-613-632-4443

P/N	D350-636-012	CHG	CHG004
DESC	Skidtube RH	STC	SH99-7
LOT	B43781	STC	SR00646SE
MODEL	AS350/355	STC	

US PATENT # 5735484
CANADA FOREIGN PATENTS PENDING

MADE IN CANADA

Scrap Parts: Old part with original work order!

Part no:	Batch no:	Qty:
AL541032225-insert	M100621	38 -
D3794-1 - gasket	B43147	1 ✓
D3794-3 - gasket	B42486	1 ✓
D3536-25-gasket	B42980	1 ✓
AN3C-5A-Bolt	M110602	34 ✓
ANBC-6A-Bolt	M108880	4 ✓
AN960C-10L-washer	M169798	38 ✓
MS21083C8-NUT	M169740	1
NAS1515H3L-washer	M106516	4

Don't lose This

Sheet!

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 05/05/2009 2:00:08 PM

User: Chantal Lavoie

JOB HISTORY : DETAIL

Job Number	: 43781	Customer	: Dart Helicopters Services LLC.
Estimate Number	: 10265	DWG Name	: 350 SKIDTUBE ASSEMBLY RH
Purchase Order #	:	Part Number	: D350636012
Complete Date	: 12/12/2008 8:14:02	DWG Number	: D2750 REV F
Rev.	: F		

DUE DATE		ORDERED		DELIVERED	
20/12/2008	1		1		

2.0 D26003BENT-Extrusion Bent INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
12/12/2008	FAUT01: Fauteux, Melanie	D26003BENT	1.000		\$44.80		Lot # 43495 Qty. 1
Subtotal:		QTD:	0	CTD:	1	\$44.80	

3.0 D2744-Cap INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
12/12/2008	FAUT01: Fauteux, Melanie	D2744	1.000		\$1.04		Lot # 39242 Qty. 1
Subtotal:		QTD:	0	CTD:	1	\$1.04	

4.0 SKIDTUBES 1 Internal Operation							
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost
29/11/2008	LEVI01: Levis, Sylvain	Run	1.000	1.75	\$33.23	1.75	74.44
01/12/2008	ELLI01: Elliott, Barclay	Run	0.000	0.58	\$11.01	0.58	24.66
01/12/2008	TITL01: Titley, Ian	Run	1.000	0.44	\$7.11	0.44	15.93
Subtotal:		QTD:	2	CTD:	0	2.77	\$166.38

7.0 HAND FINISHING1 Internal Operation							
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost
01/12/2008	TITL01: Titley, Ian	Run	1.000	0.16	\$2.59	0.63	24.74
Subtotal:		QTD:	1	CTD:	0	0.16	\$27.33

9.0 D2739-350 I Beam INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
12/12/2008	FAUT01: Fauteux, Melanie	D2739	1.000		\$48.02		Lot # 43163 Qty. 1
Subtotal:		QTD:	0	CTD:	1	\$48.02	

10.0 D34901-Cross Bolt Spacer INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
03/12/2008	ELLI01: Elliott, Barclay	D34901	4.000		\$10.15		Lot # 43013 Qty. 4
Subtotal:		QTD:	0	CTD:	4	\$10.15	

11.0 D34903-Cross Bolt Spacer INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
03/12/2008	ELLI01: Elliott, Barclay	D34903	4.000		\$56.90		Lot # 43014 Qty. 4
Subtotal:		QTD:	0	CTD:	4	\$56.90	

12.0 D2743-Crossbolt Spacer INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
03/12/2008	ELLI01: Elliott, Barclay	D2743	8.000		\$24.08		Lot # 42777 Qty. 8
Subtotal:		QTD:	0	CTD:	8	\$24.08	

REFERENCE ONLY

Date: Tuesday, 05/05/2009 2:00:08 PM
 User: Chantal Lavoie

JOB HISTORY : DETAIL

Job Number : 43781			Customer : Dart Helicopters Services LLC.					
Estimate Number : 10265			DWG Name : 350 SKIDTUBE ASSEMBLY RH					
Purchase Order # :			Part Number : D350636012					
Complete Date : 12/12/2008 8:14:02			DWG Number : D2750 REV F				Rev. : F	
13.0 SKIDTUBES 1 Internal Operation								
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost	
02/12/2008	TITL01: Titley, Ian	Run	1.000	0.56	\$9.05	0.56	20.27	
03/12/2008	ELLI01: Elliott, Barclay	Run	0.000	1.86	\$35.32	1.86	79.12	
03/12/2008	DUVA01: Duval, Jacques	Run	1.000	1.00	\$16.16	1.00	36.20	
Subtotal:			QTD:	2 CTD:	0	3.42	\$196.12	
16.0 HAND FINISHING1 Internal Operation								
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost	
05/12/2008	LAUG01: Laughren, Gary	Run	0.000	0.00	\$0.00	0.22	8.31	
05/12/2008	LAUG01: Laughren, Gary	Run	1.000	0.22	\$3.42	0.00	0.00	PROVR
Subtotal:			QTD:	1 CTD:	0	0.22	\$11.73	
17.0 POWDER COATING Internal Operation								
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost	
05/12/2008	GREG01: Gregory, Marc	Run	1.000	0.21	\$3.27	0.42	15.87	
Subtotal:			QTD:	1 CTD:	0	0.21	\$19.14	
19.0 ALS41032225-Insert INVENTORY ITEM								
DATE	EMPLOYEE	TYPE	Qty		COST			
08/12/2008	LAUG01: Laughren, Gary	ALS41032225	38.000		\$6.39			Lot # 100621 Qty. 38
Subtotal:			QTD:	0 CTD:	38	\$6.39		
21.0 D2745-Bushing INVENTORY ITEM								
DATE	EMPLOYEE	TYPE	Qty		COST			
08/12/2008	LAUG01: Laughren, Gary	D2745	8.000		\$46.67			Lot # 42778 Qty. 8
Subtotal:			QTD:	0 CTD:	8	\$46.67		
22.0 D37911-Wearplate INVENTORY ITEM								
DATE	EMPLOYEE	TYPE	Qty		COST			
08/12/2008	LAUG01: Laughren, Gary	D37911	1.000		\$26.91			Lot # 42982 Qty. 1
Subtotal:			QTD:	0 CTD:	1	\$26.91		
23.0 D37931-Wearshoe INVENTORY ITEM								
DATE	EMPLOYEE	TYPE	Qty		COST			
08/12/2008	LAUG01: Laughren, Gary	D37931	1.000		\$20.23			Lot # 42479 Qty. 1
Subtotal:			QTD:	0 CTD:	1	\$20.23		
24.0 D37933-Wearshoe INVENTORY ITEM								
DATE	EMPLOYEE	TYPE	Qty		COST			
08/12/2008	LAUG01: Laughren, Gary	D37933	1.000		\$19.06			Lot # 42927 Qty. 1
Subtotal:			QTD:	0 CTD:	1	\$19.06		
25.0 D37941-Gasket INVENTORY ITEM								
DATE	EMPLOYEE	TYPE	Qty		COST			
08/12/2008	LAUG01: Laughren, Gary	D37941	1.000		\$5.34			Lot # 43147 Qty. 1
Subtotal:			QTD:	0 CTD:	1	\$5.34		
REFERENCE ONLY								

Date: Tuesday, 05/05/2009 2:00:09 PM
 User: Chantal Lavoie

JOB HISTORY : DETAIL

Job Number	: 43781	Customer	: Dart Helicopters Services LLC.
Estimate Number	: 10265	DWG Name	: 350 SKIDTUBE ASSEMBLY RH
Purchase Order #	:	Part Number	: D350636012
Complete Date	: 12/12/2008 8:14:02	DWG Number	: D2750 REV F

26.0 D37943-Gasket INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
08/12/2008	LAUG01: Laughren, Gary	D37943	1.000	\$3.03	Lot # 42486 Qty. 1
Subtotal:			QTD: 0 CTD: 1	\$3.03	

27.0 D353525-Wearshoe INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
08/12/2008	LAUG01: Laughren, Gary	D353525	1.000	\$15.21	Lot # 43405 Qty. 1
Subtotal:			QTD: 0 CTD: 1	\$15.21	

28.0 D353625-Gasket INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
08/12/2008	LAUG01: Laughren, Gary	D353625	1.000	\$4.81	Lot # 42980 Qty. 1
Subtotal:			QTD: 0 CTD: 1	\$4.81	

29.0 D35371-Wearpad INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
08/12/2008	LAUG01: Laughren, Gary	D35371	3.000	\$82.72	Lot # 43171 Qty. 3
Subtotal:			QTD: 0 CTD: 3	\$82.72	

30.0 D36311-Washer INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
08/12/2008	LAUG01: Laughren, Gary	D36311	8.000	\$0.56	Lot # 41141 Qty. 8
Subtotal:			QTD: 0 CTD: 8	\$0.56	

31.0 D3488042-Blade Fitting Assembly, RH INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
08/12/2008	LAUG01: Laughren, Gary	D3488042	1.000	\$234.54	Lot # 43122 Qty. 1
Subtotal:			QTD: 0 CTD: 1	\$234.54	

32.0 NAS1611010-O-RING INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
08/12/2008	LAUG01: Laughren, Gary	NAS1611010	8.000	\$6.14	Lot # 109962 Qty. 8
Subtotal:			QTD: 0 CTD: 8	\$6.14	

33.0 NAS1611013-O-RING INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
08/12/2008	LAUG01: Laughren, Gary	NAS1611013	8.000	\$4.05	Lot # 106513 Qty. 8
Subtotal:			QTD: 0 CTD: 8	\$4.05	

34.0 D3492041-Plug Assembly INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
08/12/2008	LAUG01: Laughren, Gary	D3492041	8.000	\$30.85	Lot # 42936 Qty. 8
Subtotal:			QTD: 0 CTD: 8	\$30.85	

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User: Chantal Lavoie

JOB HISTORY : DETAIL

Job Number	: 43781	Customer	: Dart Helicopters Services LLC.
Estimate Number	: 10265	DWG Name	: 350 SKIDTUBE ASSEMBLY RH
Purchase Order #	:	Part Number	: D350636012
Complete Date	: 12/12/2008 8:14:02	DWG Number	: D2750 REV F
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35.0 D3492043-Plug Assembly INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
08/12/2008	LAUG01: Laughren, Gary	D3492043	8.000		\$30.87	Lot # 42997 Qty. 8
Subtotal: QTD: 0 CTD: 8 \$30.87						

36.0 AN3C5A-Bolt INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
08/12/2008	LAUG01: Laughren, Gary	AN3C5A	34.000		\$14.42	Lot # 110002 Qty. 34
Subtotal: QTD: 0 CTD: 34 \$14.42						

37.0 AN3C6A-BOLT INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
08/12/2008	LAUG01: Laughren, Gary	AN3C6A	4.000		\$1.87	Lot # 108880 Qty. 4
Subtotal: QTD: 0 CTD: 4 \$1.87						

38.0 AN6C44A-BOLT INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
08/12/2008	LAUG01: Laughren, Gary	AN6C44A	4.000		\$112.17	Lot # 110105 Qty. 4
Subtotal: QTD: 0 CTD: 4 \$112.17						

39.0 AN8C35A-BOLT INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
08/12/2008	LAUG01: Laughren, Gary	AN8C35A	1.000		\$64.09	Lot # 110105 Qty. 1
Subtotal: QTD: 0 CTD: 1 \$64.09						

40.0 AN960C10L-washer INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
08/12/2008	LAUG01: Laughren, Gary	AN960C10L	38.000		\$1.45	Lot # 109798 Qty. 38
Subtotal: QTD: 0 CTD: 38 \$1.45						

41.0 AN960C816L-WASHER INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
08/12/2008	LAUG01: Laughren, Gary	AN960C816L	1.000		\$0.18	Lot # 109632 Qty. 1
Subtotal: QTD: 0 CTD: 1 \$0.18						

42.0 MS210436-NUT INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
08/12/2008	LAUG01: Laughren, Gary	MS210436	4.000		\$13.46	Lot # 109754 Qty. 4
Subtotal: QTD: 0 CTD: 4 \$13.46						

43.0 MS21083C8-NUT INVENTORY ITEM						
DATE	EMPLOYEE	TYPE	Qty		COST	
08/12/2008	LAUG01: Laughren, Gary	MS21083C8	1.000		\$1.82	Lot # 109740 Qty. 1
Subtotal: QTD: 0 CTD: 1 \$1.82						

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Date: Tuesday, 05/05/2009 2:00:09 PM

User: Chantal Lavoie

JOB HISTORY : DETAIL

Job Number	: 43781	Customer	: Dart Helicopters Services LLC.
Estimate Number	: 10265	DWG Name	: 350 SKIDTUBE ASSEMBLY RH
Purchase Order #	:	Part Number	: D350636012
Complete Date	: 12/12/2008 8:14:02	DWG Number	: D2750 REV F
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44.0 NAS1515H3L-WASHER INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
08/12/2008	LAUG01: Laughren, Gary	NAS1515H3L	4.000		\$0.92		Lot # 106516 Qty. 4
Subtotal:		QTD:	0	CTD:	4	\$0.92	

45.0 HAND FINISHING1 Internal Operation							
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost
08/12/2008	LAUG01: Laughren, Gary	Run	1.000	1.75	\$27.21	1.75	66.12
Subtotal:		QTD:	1	CTD:	0	1.75	\$93.33

48.0 D2741-Blade, 350 Skidtube INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
10/12/2008	QUIR01: Quirion, Sonia	D2741	1.000		\$90.62		Lot # 42222 Qty. 1
Subtotal:		QTD:	0	CTD:	1	\$90.62	

49.0 AN960C816L-WASHER INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
10/12/2008	QUIR01: Quirion, Sonia	AN960C816L	2.000		\$0.37		Lot # 109632 Qty. 2
Subtotal:		QTD:	0	CTD:	2	\$0.37	

50.0 MS21083C8-NUT INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
10/12/2008	QUIR01: Quirion, Sonia	MS21083C8	2.000		\$3.65		Lot # 109840 Qty. 2
Subtotal:		QTD:	0	CTD:	2	\$3.65	

51.0 AN8C21A-BOLT INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
10/12/2008	QUIR01: Quirion, Sonia	AN8C21A	2.000		\$53.18		Lot # 109772 Qty. 2
Subtotal:		QTD:	0	CTD:	2	\$53.18	

52.0 NAS1515H8L-WASHER INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
10/12/2008	QUIR01: Quirion, Sonia	NAS1515H8L	2.000		\$0.40		Lot # 108964 Qty. 2
Subtotal:		QTD:	0	CTD:	2	\$0.40	

53.0 D34931-Washer INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
10/12/2008	QUIR01: Quirion, Sonia	D34931	2.000		\$12.74		Lot # 43453 Qty. 2
Subtotal:		QTD:	0	CTD:	2	\$12.74	

54.0 D35321-Spacer INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
10/12/2008	QUIR01: Quirion, Sonia	D35321	2.000		\$7.29		Lot # 42350 Qty. 2
Subtotal:		QTD:	0	CTD:	2	\$7.29	

REFERENCE ONLY

		TIME	COST	
	Machine Time:	9.21	\$365.66	
	Labor:	8.53	\$148.37	
	Sub-contract (external Op.):		\$0.00	
	INVENTORY ITEM:		\$1101.00	
	SUB-COMPONENT (SUB-JOB):		\$0.00	
Total:			\$1615.03	
COST PER UNIT:			\$1615.03	